

Work Order ID 111720

111720

Page 1

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Item ID: D412-630-033

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/21/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev N

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-033 CHG004

DAS
6
1-89

14-1-24

22

14-01-24

110

0.00

110

Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M123777

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M122900

DAS
36
9-89

22

14/01/23

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Item ID: D412-630-033 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ LH Folding
 Start Date: 1/20/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/21/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				2			
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				2			DAS 33 9-89/4-01-20
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				2	14-1-24		DAS 6 9-89 14-1-24

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Item ID: D412-630-033

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/21/14 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: <u>053</u>								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

8 14-1-24

DAS

6

9-89

MCJ 14-01-24(H) 14-01-24

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Work Order ID: 111720
 Parent Item: D412-630-033
 Parent Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14
 Start Qty: 2.00

Required Date: 1/21/14
 Required Qty: 2.00

7

Comments: IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B ecn 1019, added d2807-041 EC verified by:DD
 IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004
 DD vef:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107 Clevis		Manufactured	No			110	Each	75.0000	1	2		14/01/23	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST003		45							
				89927		45							
				WA004		30							
				105277		2				2			
				107925		12							
				108710		16							
D2803-041 Bracket Assembly		Manufactured	No			110	Each	6.0000	1	2		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST148		6							
				108113		6				108113			
D2804-041 Bracket Assembly		Manufactured	No			110	Each	13.0000	1	2		DAS 33 9-89	14-01-21
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST148		13							
				101703		5							
				105560		1							
				108063		5							
				110851		2				110851			

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Required Qty: 2.00

DAS

33

9-89

109732

DAS

22

9-89

10789

DAS

36

9.99

DAS

23

107893

DAS

22

9.89

126192

DA

12717

15

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Work Order ID: 111720

Parent Item: D412-630-033

Parent Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14

Required Date: 1/21/14

Start Qty: 2.00

Required Qty: 2.00

AN310C8	Purchased	No	110	Each	46.0000	2	4	DAS 33 9-89
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST342	46	
m126192	21	
m127290	25	

126/92

MS24665-302	Purchased	No	110	Each	168.0000	6	12	DAS 33 9-89
Cotter Pin								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	36	
120521	36	
ST299	132	
m127305	132	

127305

NAS1515H3	Purchased	No	110	Each	134.0000	4	8	DAS 33 9-89
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
123301	10	
ST297	124	
m127227	34	
m127306	90	

127227
4x

14/01/23

DAS
36
9-89

NAS1515H5L	Purchased	No	110	Each	305.0000	4	8	DAS 33 9-89
Washer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
103691	40	
ST297	265	
125621	265	

125621

14-01-21

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Work Order ID: 111720

Parent Item: D412-630-033

Parent Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14

Required Date: 1/21/14

Start Qty: 2.00

Required Qty: 2.00

NAS1515H8 Purchased No

110 Each 83.0000 4 8 33
9-89

Location	Loc Qty	Loc Code
ST297	83	
m127255	33	
m127376	50	

127255

MS21043-3 Purchased No

110 Each 861.0000 4 8 DAS
22
9-89

Location	Loc Qty	Loc Code
FG	80	
103691	80	
GA	4	
m126741	4	
ST315	777	
124555	92	
m126741	685	

126741

MS24693-C280 Purchased No

110 Each 72.0000 2 4 DAS
33
9-89

Location	Loc Qty	Loc Code
ST300	72	
m127305	72	

127305

D2806-1 Bushing DAS 6 9-89

Manufactured No

130 Each 58.0000 2 4 DAS
33
9-89

Location	Loc Qty	Loc Code
ST018	58	
103888	17	
109120	41	

103888

D2806-3 Bushing DAS 6 9-89

Manufactured No

130 Each 57.0000 2 4 DAS
33
9-89

Location	Loc Qty	Loc Code
ST018	57	
103889	17	
109121	40	

103889

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Work Order ID: 111720

Parent Item: D412-630-033

Parent Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14

Required Date: 1/21/14

Start Qty: 2.00

Required Qty: 2.00

D2810-5 Strip	Manufactured	No		130	Each	6.0000	1	2	DAS 33 9-89
DAS 6 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST253	6					
			100851	2					
			109455	4			109455		
D3396-1 Spacer	Manufactured	No		130	Each	87.0000	2	4	DAS 33 9-89
DAS 6 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST041	87					
			105459	5			105459		
			107894	42					
			108641	40					
AN4C6A Bolt	Purchased	No		130	Each	423.0000	1	2	DAS 33 9-89
DAS 6 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			FG	14					
			103344	4					
			121657	10					
			ST355	409					
			m125709	409			125709		
AN4C10A BOLT	Purchased	No		130	Each	30.0000	1	2	DAS 33 9-89
DAS 6 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST356	30					
			M126105	30			126105		
AN5C15A Bolt	Purchased	No		130	Each	68.0000	2	4	DAS 33 9-89
DAS 6 9-89			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST337	18					
			M126180	18			126180		
			st503	50					
			M127290	50					

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Work Order ID: 111720

Parent Item: D412-630-033

Parent Item Name: Heli-Access-Step™ LH Folding

Start Date: 1/20/14

Required Date: 1/21/14

Start Qty: 2.00

Required Qty: 2.00

AN44G7A Eyebolt DAS 6 9-89	Purchased	No		130	Each	13.0000	1	2	DAS 33 9-89	DAS 31 9-89
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>				
			ST361	13						
			m127933	13			127933			
AN4G15A Bolt DAS 6 9-89	Purchased	No		130	Each	65.0000	2	4	DAS 33 9-89	
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>				
			FG	10						DAS 31 9-89
			120360	10						
			ST357	55						
			m126175	55			126175			
NAS1515H4 Washer DAS 6 9-89	Purchased	No		130	Each	197.0000	7	14	DAS 33 9-89	DAS 31 9-89
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>				
			ST297	197						
			125574	197			125574			
NAS1515H5 Washer DAS 6 9-89	Purchased	No		130	Each	228.0000	7	14	DAS 33 9-89	
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>				
			FG	40						DAS 31 9-89
			103691	40						
			ST297	188						
			125574	188			125574			
MS21043-4 Nut DAS 6 9-89	Purchased	No		130	Each	580.0000	4	8	DAS 33 9-89	14-01-21
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>				
			FG	40						DAS 31 9-89
			104603	40						
			GA	43						
			125807	43						
			ST509	497						
			m127255	497			127255			

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Work Order ID: 111720

Parent Item: D412-630-033

Start Date: 1/20/14

Required Date: 1/21/14

Parent Item Name: Heli-Access-Step™ LH Folding

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

130

Each

237.0000

3

6

DAS

33

9-89

14-01-21

Nut

Location

Loc Qty

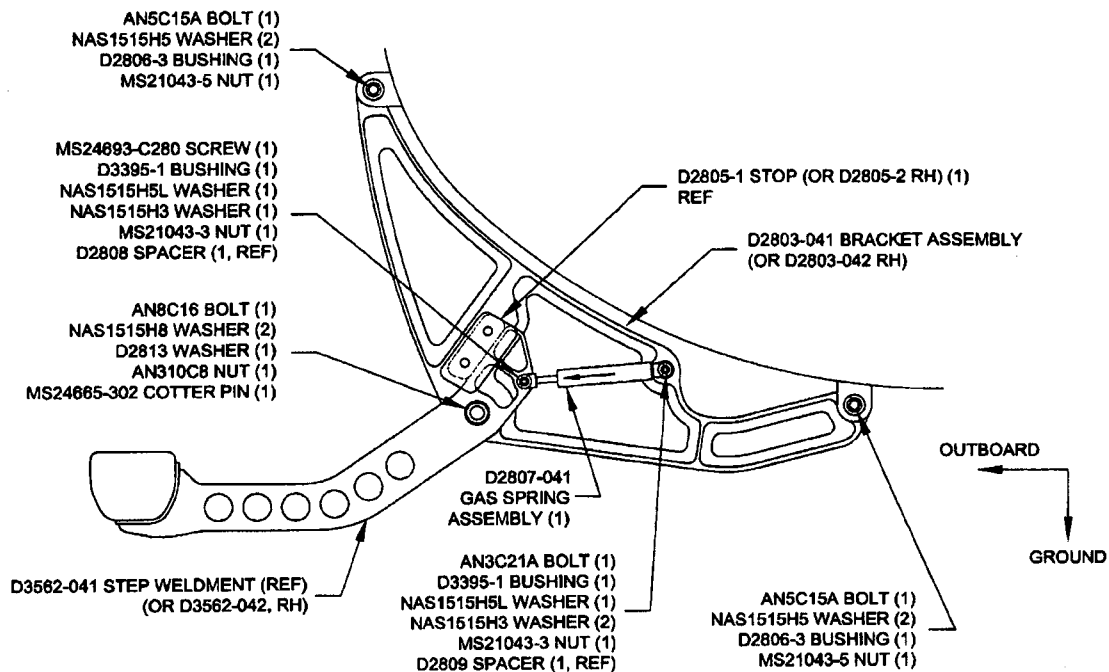
Loc Code

FG	20
101418	20
GA	88
116548	88
ST315	129
121584	129

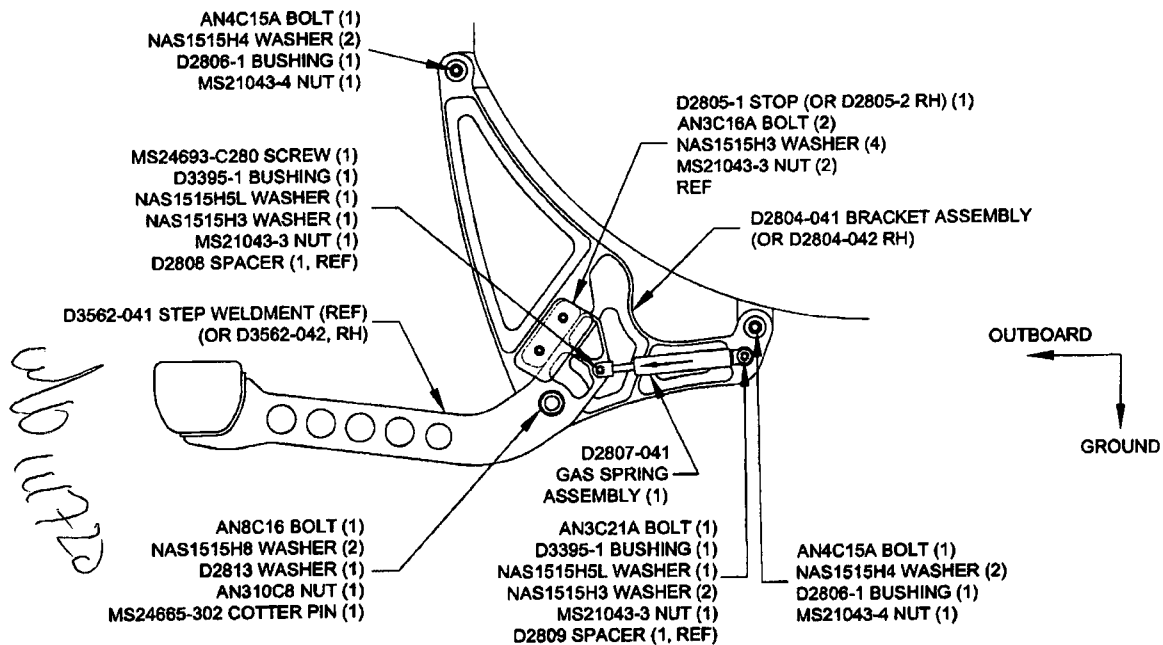
DAS
6
9-89

DAS
31
9-89

121584

D412-630-033/-034 Heli-Access-Step™ Installation

**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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REFERENCE ONLY

DAS
6
9-89

D412-630
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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
[2]	2			D2806-1	BUSHING
[2]	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
[1]	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
[2]	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
[1]	1			AN4C6A	BOLT
[1]	1			AN4C10A	BOLT
[2]	2			AN4C15A	BOLT
[1]	1			AN44-G7A	EYEBOLT
[2]	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
[7]	7			NAS1515H4	WASHER
[7]	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
[4]	4			MS21043-4	NUT
[3]	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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